









Work Order ID 69600

Thursday, May 12, 2011 3:25:51 PM



Page 1

Item ID: D2332-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Lid Prop Assembly 6.69" long
Start Date: 5/12/2011 Start Qty: 10.00  Cust Item ID:
Required Date: 5/24/2011 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan:  Date: 11-05-12 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2332	Rev C1								

100

0.00



Small Fab

Small Fab

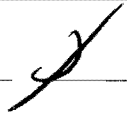
Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

10  M-11/05/18

110

0.00

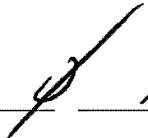


Brake NC

Brake NC

Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)10  M-11/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69600

Thursday, May 12, 2011 3:25:51 PM



Page 2

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 5/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Small Fab

Memo

0.00

Small Fab

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

10 / M-11/05/18

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/05/18

(10)

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: M114509

11-5-19. (X10)

W/O:		WORK ORDER CHANGES					
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Work Order ID 69600

Thursday, May 12, 2011 3:25:51 PM



Page 3

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 5/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

B11-05-19

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/15/19

(X10)

170



Small Fab

Small Fab

Memo

1- Tumble

2- Assemble as per dwg D2332

0.00

0.00

B11-5-25

(10)

8/5/11/05/27 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 69600

Thursday, May 12, 2011 3:25:51 PM



Page 4

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Start Date: 5/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

SB 11/05/27



Quality Control

190

Identify as per dwg & Stock Location: 512

0.00



Packaging

Memo

0.00

Packaging

11/5/27

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/30
MF
11-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:25:57 PM

Page 1

Work Order ID: 69600

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long



Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.250 		Purchased	No			100	f	11.7274	0.1	1.052632			
304 SS Round bar .250													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT028		11.727368							
				114482 ✓		11.727368							
M304TR1.000W.049 		Purchased	No			100	f	35.0600	0.43	4.526316			
304 RD Tube 1.00 x .049W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT018		35.06							
				108756		2.4							
				111457		12.66							
				117598 ✓		20							
M304TR0.500W.035 		Purchased	No			110	f	303.9907	1.25	13.15789			
304 RD Tube .500 x .035W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT017		303.99068							
				115535		2.33							
				116720		1.66068							
				117598 ✓		300							

M-L 11/05/18

1.052632

M-L 11/05/18

4.526316

M-L 11/05/17

13.15789

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 69600

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 10.00

Required Qty: 10.00

AN4-4A

Purchased

No

170

Each

117.0000

1

10



Bolt

Location

Loc Qty

Loc Code

FP-B

48

114615

48

ST356

69

114615

69

AN960JD416L

NAS1149D0416J

Purchased

No

170

Each

3.0000

3

30



Washer

40 M114884 (30x)

Location

Loc Qty

Loc Code

FP-B

3

110153

3

MS21042L4

Purchased

No

170

Each

4,971.000

1

10



Nut

Location

Loc Qty

Loc Code

ST300

4971

114718

16

116823

1155

117441

3000

117601

800

Thursday, May 12, 2011 3:25:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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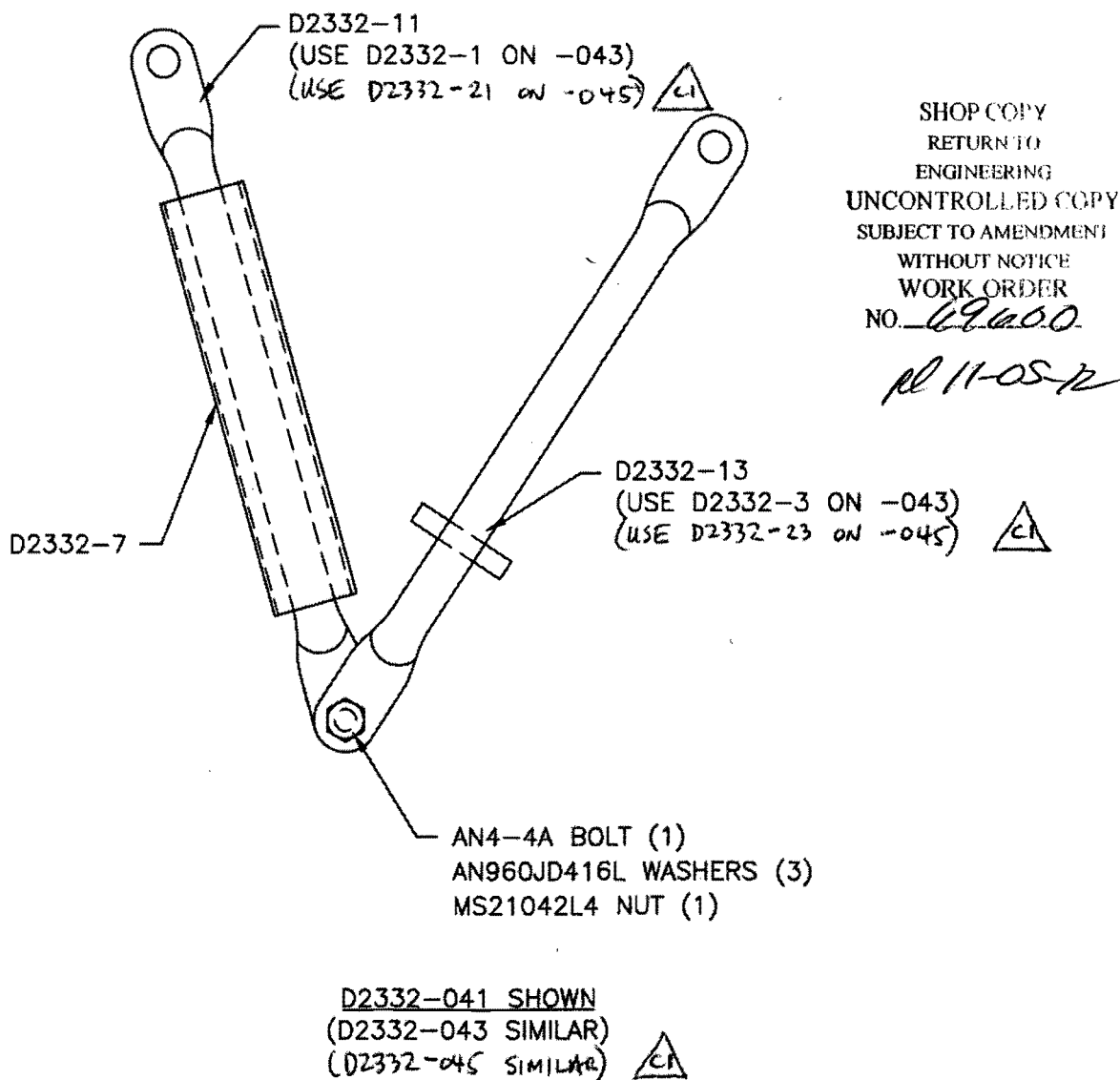
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	# 03.08.06	ADD -045 PROP (7.35" LONG)	

RELEASED
03.07.04



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69600

PL 11-05-12

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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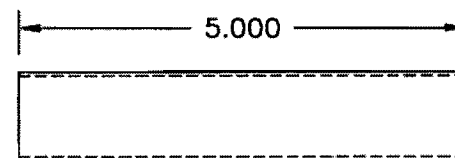
NOTE: Date & initial all entries

DART

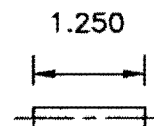


DESIGN	DRAWN BY	DART AEROSPACE LTD
#	#	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2332
DATE	TITLE	REV. C
03.07.03	LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2

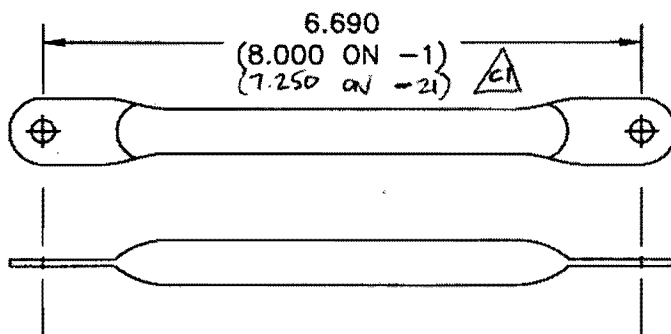
C	# 03.07.03	MAKE - 041 PROP 6.69" LONG (1ST)
C1	# 03.08.06	MAKE - 043 PROP 8.00" LONG (1ST)
		ADD - 045 PROP (7.25" LONG)



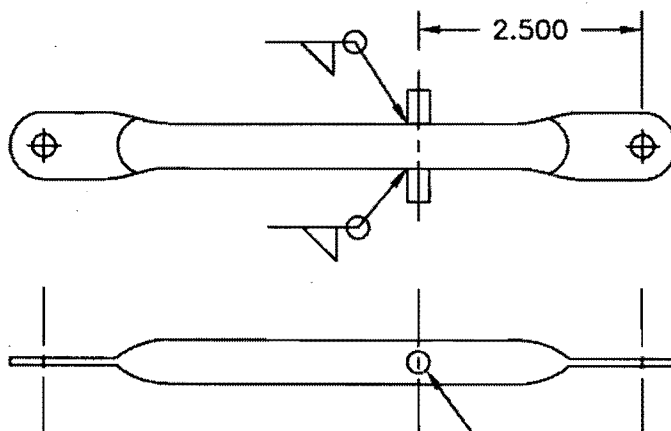
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

DRILL 1/4 HOLE FOR D2332-5

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

also 0900

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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